Work Orde September-23-1.				*	10	72	48*						Page 1
Revision ID:	D4030-041 Long Basket As	combly (250)	A	ccept		*	N900	1 040	100)* s	etup Star Stop	i VI	S1* S2*
Item Name: Start Date: Required Date:	10/07/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*				Cust Item Customer				_	IN	5 /
Reference:			•										
Approvals:	Process Plan	: MLJ	Date: 13-09-23	Tooling	(:			Date:		R	un Star	17	R1*
	QC:		Date:	SPC (Y	/N):		I	Date:			Stop	*N	R2*
Sequence ID/ Work Center II		Operation Description		Set U Run	Jp/ Hours	<u> </u>	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revis	sion Nbr											
D4030	D	i i											
100		Pick Kit		0.00							DAG		
100 Packaging Packaging		Memo		0.00						_/		13-	10-17
110		Assemble as per dwg		0.00						í	(000	3/10/18
110 HandFinish		Memo		0.00						11	4	y 1	3/10/11
Hand Finishing		****Mask l	abel plate to size of D4086 la r label, apply label ****	ibel, use so	otchbrite	e red pad	to lightly						
120 * 120 *		QC5- Inspect part compl	leteness to step on W/O	0.00		DAS 27 9-89)			
QC Quality Control		Memo		0.00	13	101	8						

Quality Control

											DC	QA:	Date:	•
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPD	DATE				
											QA Close	ed:	Date:	
Work Orde	er.					DISPOSITION		l		AGAINST DE	PARTME	NT/PR	OCESS	
Part I	- . No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Prod. E	Water Jet Ing. Coor. Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	ı	Initial	Acti	ion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	iption	Date	V	/erification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
							AUL	LT CATE	GORY					
Landi	ding Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube				o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		- 1 '	on Incomplete ions Incomplete/U nance led	Inclear	Ovalized Over/Un Part Inco Part Lost Part Mov Positione Power Lo	rrect /Missin red ed Wror	ng	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in	n Bend			Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde				*107	7248*				Page 2
Item ID: Revision ID:	D4030-041	Accombine (250)		Accept	*N9000	<u>140100</u>)* Setup	Start Stop	*NS1*
Item Name: Start Date: Required Date: Reference:	10/07/13	Assembly (350) Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID Customer:):		·	*NS2*
Approvals:	Process Pla		Date:	Tooling: SPC (Y/N):	Dat		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 130 *130* Packaging Packaging)	Operation Description Identify as per dwg & St	ock Location:	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool# Plan Code OAS 6	Qty Q		Reject Insp. Number Stamp
140 *1 4\O *		QC21- Final Inspection	Work Order Release	0.00			4	}//	! 13-11-06
Quality Control		Memo		0.00				/ '	

Quality Control

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE			
									QA Closed:	Date:	
Work Orde	ıř.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Work Order Update	1 I	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	ł.	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
NCKI	10.				work Order Opdate	¹	carge Fab	Composite	1	20hhilei [
Root Cause	Date	Step	Qty		ption of work order update	Initial Chief Eng	Act Descr	ion ription	Sign & Date	Verification	QC Inspector
Doc/Data		Step	α.,		or worr comormance	Ciner Ling	26361	TPETOTI .	3010	vermeation	Qospecto.
Equip/Tooling											
Operator											
Material											
Setup											
Other		. '	+		•						
Process					·						
Supplier											
Training											
Unapproved											
					F	AULT CATE	GORY				
Landi	ng Gear				General				_		_
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushed	/Crimped			Burrs	Instruc	tions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved		
	Heat Tre	at			Countersink	Mislabe	eled		Positioned V	Vrong	<u> </u>
	Inspection	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other
	Ripples i	n Bend			Drill Holes	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

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Picklist Print

September-23-13 11:44:29 AM

Work Order ID:

107248

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

IPP Rev:B as per dwg revB DD

10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:ILM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on e Hand	Qty per Kit	Total Qty		ate Status sued
D4086-200		Manufactured	No				Each	14.0000		1	DAS	12 10 12
Placard, Max Load				886		Loc Qty 14 10		oc Code			28 9-89	1 <u>3-1</u> 0-17
D2530 Handle Weldment		Manufactured	No	962 985		100	Each	7.0000	1	1	DAS28	
				Location ST255 103 921 980	30	Loc Oty 7 1 2 4	<u>1</u>	Loc Code	_B1	<u>07144</u>	9-89	
D2535 Spring		Manufactured	No			100	Each	135.0000	2	2	DAS 28	·
					9552 9576	Loc Oty 135 98 37		oc Code		RX.	9-89)

											DQA.	Date	·
NCR: Y	es .	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPDATE		QA Closed:	Date	: :
Work Orde	···	· ·				DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS	
Part N	 No.	~				Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root	T		**		Descri	ption of work order update		nitial	Action		Sign &		
Cause	1	Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup	П												
Other													
Process	П	-											
Supplier													
Training			ļ Ē			•							
Unapproved			<u> </u>				<u> </u>						
							AUL	T CATE	GORY				
Landi	ng G	ear				General		-		_	7	-	 1
	Цi	Bending				Bend	L	Grain		L	Ovalized	1	Pressure/Forced
	Ц	Centre No	ot Conce	ntric to	O/S	BOM/Route	L	Hardwa	re	<u>_</u>	Over/Under	tolerance	Temperature/Cure
	Ц	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorred	⊢	Weld
	Crushed/Crimped					Burrs		-1	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance	_	Part Moved		
		Heat Trea	it			Countersink		Mislabe	eled		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Cut Too Short Drill Holes

Drawing Finish

Folio

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

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	Work Order ID:	107248										
	Parent Item:	D4030-041							Start 1	Date: 10/07/13	Req	uired Date: 10/07/13
	Parent Item Name:	Long Basket Asse	embly (350)						Start	Qty: 1.00	Re	quired Qty: 1.00
	D2537 Bushing		Manufactured	No			100	Each	134.0000	2	2	DAS 28-13-10-17
					Location		Loc Qty		Loc Code			9-89
					ST008		30					
					10	2982	30					
					ST011		104					
						0454	38			-2;		
						3608	24					
						3861 426	40 2					,
_	D3913-041		MC	No	70	420	100	Each	0.0000	1		, bas/
	Long Basket Base Assen	nbv. 350	Manufactured	NO			100	Eacii	0.0000	1310	7239 5	e 38
	. D3914-041	,	Manufactured	No			100	Each	0.0000	1	1	12/0/9-89
	Long Basket Lid Assemb	oly (350)	Manufactured							-016	37 205	OAS C
	D3917-3 Washer		Manufactured	No			100	Each	207.0000	6	6	989 DAS 17 (15) (17)
					Location		Loc Qty		Loc Code			9-89
					ST072		207					·
						0397	46			6	X	
						3536	41					
					10	4859	120			<u></u>		- 14
	D3953-3 Gas Spring Stud, Lid		Manufactured	No			100	Each	35.0000	2	2	DAS 28
					Location		Loc Qty		Loc Code			9-89
					GA		1					
						592	1				************	
					ST076		34				· · · · ·	
						2196	20			-2 x		
					88	494	14				-	

											DQA:	Dat	:e:	
NCR: Y	'es	/ No				WORK ORDER NON-C	O	NFORN	MANCE / UPE	DATE	QA Closed:	 Dat	·e· _	
						DISPOSITION				AGAINST DE	-	*****		
Work Orde	er: -					Rework	Į į		Skid-tube	Crosstube	1	Water Jet	\neg	Engineering
Part N	۱o	· · · · · · · · · · · · · · · · · · ·				Scrap Use-as-is		Therm	Machining noforming	Small Fab Finishing	4	d. Eng. Coor. re/Packaging		Quality Other
NCR N	۱o. ₋				 	Work Order Update			Large Fab	Composite]	Supplier		
Root		:			Descri	ption of work order update	Ī	nitial	Act	ion	Sign &			
Cause	\Box	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	1	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved				,	· •	·								
						·	AUL	T CATE	GORY			·		
Landi	_					General		Grain			Ovalized	· [—],	Pressure/Forced
	-	Bending	nt Conce	ntric to		Bend BOM/Route	┝	Hardwa	ro	<u> </u>	Over/Under	tolerance		Temperature/Cure
	Centre Not Concentric to O/S BOM/Route Cracks Broken/Damaged							4	ion Incomplete		Part Incorre	ŀ	_	Weld
	Crushed/Crimped Burrs							Instruct	ions Incomplete/U	Jnclear	Part Lost/M	issing	\	Wrong Stock Pulled
	Cuffs Contamination							Mainte	enance		Part Moved			
	Heat Treat Countersink							Mislabe	eled		Positioned V	Vrong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	'Surge [Other
		Ripples in	Bend			Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:	107248							
Parent Item:	D4030-041					Start	Date: 10/07/13	Required Date: 10/07/13
Parent Item Name:	Long Basket Assembly (350)					Star	t Qty: 1.00	Required Qty: 1.00
D3953-7 Spring Spacer	Manufactured	No		100	Each	84.0000	2	UAS 12-10-12
			Location	Loc Qty		Loc Code		28 9-89
			ST076	84				
			100414	14			$-2\times$	
			102928	24			***************************************	
			105465	45				
D3953-9		No	99148	100	rt	(0.0000		DAS
Gas Spring Washer	Manufactured	NO		100	Each	69.0000	2 2	28
Gas Spring Washer			•					9-89
			Location	Loc Oty		Loc Code		· <u>-</u>
			ST076	69				•
			102166 103615	21 46			$-2\times$	•
			94719	2				
			95127	0				
D3953-17	Manufactured	No		100	Each	14.0000	2	DAS
Gas Spring Spacer								28 9-89
			Location	Loc Qty		Loc Code		9-09
			ST075	14				
			100353	14			$\overline{2}$	
D3953-19 Gas Spring Bracket	Manufactured	No	***************************************	100	Each	11.0000	1 1	DAS 28
			<u>Location</u>	Loc Oty		Loc Code		9-89
			ST077	11		<u> Lot codt</u>		
			100341	11				
D3953-21 Gas Spring Bracket	Manufactured	No		100	Each	11.0000	1 1	DAS 28
ab2 a			<u>Location</u>	Loc Qty		Loc Code	37-74-5-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-	9-89
			ST077			Loc Code		
			100404	11 11			17	
			100404	11			-+×-	

												DQA:	Da	te:	
NCR: Ye	es	/ No				WORK ORDER NON-	100	VFORM	MANCE / UP	DATE		·			
= . =												QA Closed:	Da	te:	
Work Orde	r .					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	-					Rework			Skid-tube	Crosstube Small Fab	_	Pro	Water Jet d. Eng. Coor.		Engineering Quality
Part N	o. -					Scrap Use-as-is	- '	ı	Machining noforming	Finishing			e/Packaging	-	Other
NCR N	o					Work Order Update]	mem	Large Fab	Composite	-	Nec/stor	Supplier		
Root	Т				Descri	ption of work order update		Initial	Ac	ction		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling							l								
Operator							-								
Material	_		l.												
Setup									Ì						
Other	_		1									ļ			
Process			ļ												
Supplier															
Training	_								1						
Unapproved			<u> </u>		<u> </u>				<u> </u>						
							AUI	LT CATE	GORY						
Landin	ng G	iear			_	General	_	-				7		_	1
Bending						Bend		Grain				Ovalized		_	Pressure/Forced
[Centre No	ot Conce	ntric to	o/s	BOM/Route	<u>_</u>	Hardwa				Over/Under	tolerance	L	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete			Part Incorred	ct		Weld

instructions incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

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Work Order ID:	107248								
Parent Item:	D4030-041					Start	Date: 10/07/13		Required Date: 10/07/13
Parent Item Name:	Long Basket Assembly (350)					Start	Qty: 1.00		Required Qty: 1.00
D3969-3 Gas Spring	Manufactu	red No		100	Each	49.0000	1	1	DAS 2813-10-17
			Location	Loc Qty		Loc Code			9-89
			ST262	49				_	
			100611 99623	32 17			!X	_	
AN3-14A Bolt	Purchased	No		100	Each	115.0000	4	4	DAS 28
			Location	Loc Qty		Loc Code			9-89
			ST351	14			777		
			m125709	14					
			ST511	100					
			m126192	100			4X		
			ST512	1				_	
AN3-16A Bolt	Purchased	No	123759	100	Each	159.0000	2	2	DAS 28
			Location	Loc Oty		Loc Code			9-89
			GA	47		<u> Doc Couc</u>			
			117441	47				_	
			ST352	112					
			122407	8					
			M125952	6				_	
			M126192	- 98			_2×		

NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UPD	ATE			
											QA Closed:	Date	•
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	- _ No.	•				Rework Scrap Use-as-is Work Order Update		l Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root						ption of work order update	1	nitial	Acti	on	Sign &		
Cause	.	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	T CATE	GORY				
Landi	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube			o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		4 '	on Incomplete ions Incomplete/U nance led	nclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
	П	Ripples in	Bend			Drill Holes		Offset		.		-	

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

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Page 5

Work Order ID:	107248									
Parent Item:	D4030-041						Start Da	ite: 10/07/13		Required Date: 10/07/13
Parent Item Name:	Long Basket Assembly	(350)					Start Q	ty: 1.00		Required Qty: 1.00
AN5-17A Bolt	P	urchased	No		100	Each	403.0000	4	4	DAS 28 13-10-17 989
				Location	Loc Qty		Loc Code			505
				GA	36					
				117872	36			i		
				ST337	4					
				124215	2					
				124805	2				<u>_</u>	
				st503	213					
				m126176	213		•	$-4\times$		
				ST514	150					
				125388	150					DAS
AN4-12	p	Purchased	No		100	Each	119.0000	3	3	28
Bolt										9-89
				Location	Loc Qty		Loc Code			
				ST356	119					
				124805	5					
				m125709	50					
				m126193	64			_3>		
AN310-4	P	Purchased	No		100	Each	138.0000	3	3	DAS
Nut								·		28 9-89
				Location	Loc Qty		Loc Code			9-69
				ST342	138				***	
				112969	2					
				122800	2					
				M125716	34			_3;	L	
				M126400 M126872	50 50					
				IVI I 200 / 2	30					

												DQA:	Dat	te:	
NCR: Y	⁄es	/ No				WORK ORDER NON-O	100	NFOR	MANCE / UP	DATE		•		•	
												QA Closed:	Dat	te:	
Work Orde	a r ·					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
Work Orde	-1					Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	No.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
ļ	•					Use-as-is			noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	۷o					Work Order Update]		Large Fab	Composite		l	Supplier		
Root	1				Descri	ption of work order update	T	I Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	1	or Non-conformance	1	nief Eng	Desc	cription		Date	Verification	n	QC Inspector
Doc/Data															
Equip/Tooling															
Operator	Щ		:												
Material	Ш														
Setup	Ш		:		Ì										
Other	Ш	•													
Process	Ш	~ .~													
Supplier	Ш														
Training	Ш		ļ				1								
Unapproved				<u></u>											
						F	AUI	LT CATE	GORY						
Landi	ng G	Gear				General	_	-				-		,	•
		Bending				Bend	L	Grain				Ovalized		_	Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		L	Over/Under	tolerance	L	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete			Part Incorred	t .		Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Work Order ID:	107248										
Parent Item:	D4030-041						Start D	ate: 10/07/1	3 R e	equired Date	: 10/07/13
Parent Item Name:	Long Basket Assembly (350)						Start (Qty: 1.00	R	equired Qty	: 1.00
AN310C4 Nut	Purchas	sed No			100	Each	126.0000	2	2	DAS 28	13-10-17
			Locatio	<u>n</u>	Loc Qty		Loc Code			9-89	
			ST342		126						
				122993	24			2			
				123831	2				/		
				126192	50						
				M125952	50						
MS21042L3 Nut	Purchas	sed No			100	Each	5,946.0000	6	6	DAS	
			Locatio	<u>n</u>	Loc Qty		Loc Code		,	28 9-89	1,1
			FP001		3						
				122141	3						
			GA		18						
				122452	18						
			ST314		304						
				111668	I				, _		
				117885	32						
				119017	55						
				119075	138						
				123265	43						
				M126036	35						
			ST506		1249						
				123900	870						
				124291	379						
			ST510a		4372						
		•		M126275	372						
				M126333	4000			1/0	X		

										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-C	100	VFORI	MANCE / UPDATE		04.61	D-4-	,
					T					QA Closed:	Date	
Work Orde					DISPOSITION			AGAINST [)El	PARTMENT	PROCESS	
work Orde	·				Rework	1		Skid-tube Crosstube	\neg		Water Jet	Engineering
Part N	lo.				Scrap			Machining Small Fab	\dashv	Pro	d. Eng. Coor.	Quality
raitiv					Use-as-is	1		noforming Finishing	ᅱ		re/Packaging	Other
NCR N	lo.				Work Order Update	1		Large Fab Composite	-		Supplier	
						,						
Root				Descri	ption of work order update		Initial	Action	\Box	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data										1		
Equip/Tooling	K *	į							,			
Operator												
Material	^	1							Î			
Setup									1			
Other			1	1		1						
Process				ļ								
Supplier	_					1						İ
Training												
Unapproved		1						<u> </u>		<u> </u>		
						AUI	LT CATE	GORY	—			
Landir	ng Gear			_	General	$\overline{}$	٠ .	г		1	Г	7
	Bending				Bend	<u> </u>	Grain	-		Ovalized	<u> </u>	Pressure/Forced
		ot Conce	ntric to	o/s	BOM/Route	\vdash	Hardwa	}	_	Over/Under	F-	Temperature/Cure
	Cracks			_	Broken/Damaged	\vdash	⊣ `	ion Incomplete	_	Part Incorred	<u> </u>	Weld
		/Crimped		_	Burrs	\vdash	-	tions Incomplete/Unclear	—	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	\vdash	-	enance		Part Moved	Mrong	
1 1	Heat Tre	at			Countersink	1	Mislab	eiea		Positioned V	vrong	

Misread

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

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Picklist Print

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Page 7

Work Order ID:	107248		-									
Parent Item:	D4030-041							Start I	Date: 10/07/1	3	Required Date:	10/07/13
Parent Item Name:	Long Basket Assen	ably (350)						Start	Qty: 1.00		Required Qty:	1.00
MS21042L5 Nut		Purchased	No			100	Each	999.0000	4	4	DAS 28	13-10-1
				Location		Loc Oty		Loc Code			9-89	
				ST314		39						
					125654	39				•		
				ST506		1						
					123900	1						
				st507		959			uriii.			
					125535	959			<u> </u>	<u>X</u>		
MS24665-151		Purchased	No		-	100	Each	183.0000	3	3	_	
Cotter Pin											DAS	
				Location		Loc Qty		Loc Code			28 9-89	
				GA		28						
					17566	28						
				ST323		155						
					122802	20						
					124859	4				,		
					125646	131			0) X _		
MS24665-300		Purchased	No			100	Each	151.0000	2	2		
COTTER PIN											DAS	4.0
				Location		Loc Oty		Loc Code			28 9 -8 9	
				GA		37					5-05	
					118234	37						
				ST299		114			<u></u>			
					124555	114				X		

											DQA:	Date:	
NCR: Y	⁄es	/ No				WORK ORDER NON-	OI	VFORI	MANCE / UP	DATE	QA Closed:	Date:	
Maril Orda						DISPOSITION				AGAINST DE			
Work Orde Part N NCR N	- _ No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance	i	Initial nief Eng		ction cription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		***											
						F	AUI	LT CATE	GORY				
Landi	ing G	ear				General					_		7
		Bending Centre No	ot Conce	ntric to	o/s	Bend BOM/Route Broken/Damaged		Grain Hardwa	are ion incomplete	-	Ovalized Over/Under Part Incorre	 	Pressure/Forced Temperature/Cure Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Work Order ID:	107248										
Parent Item:	D4030-041						Start D	ate: 10/07/1	3 R	equired Date:	10/07/13
Parent Item Name:	Long Basket Assembly (350)						Start (Qty: 1.00	F	Required Qty:	1.00
NAS1149F0432P WASHER	Purchas	sed No			100	Each	2,044.0000	6	6	DAS	13-10-17
			Location	<u>n</u>	Loc Qty		Loc Code			9-89	
			ST295		81						
				122151	2						
				123522	4						
				123900	6						
				124580	13						
				124859	15						
				125268	41						
			ST510a		1963						
				M126221	1963			_6	<u>X</u>	DAS	
NAS1149F0563P	Purchas	sed No			100	Each	586.0000	4	4	28 9-89	
Washer										9-89	
	•		<u>Locatio</u>	<u>n</u>	Loc Oty		Loc Code				
			ST295		586						
				121350	586			4	X		
NAS1149F0332P	Purchas	sed No			100	Each	8,538.0000	8	8		
Washer										DAS_	
			Locatio	<u>n</u>	Loc Qty		Loc Code			28	
			GA		182					9-89	
				122063	182						
			ST294		158			- 1.			
			0.2,	122063	158						
			ST295		3			-			
			312/3	123352	3						
			-4610	123332	3195						
			st510	122000				3			
			07.	123900	3195			- 47			
			ST510a		5000						
				125646	5000						

NCR:	⁄es	/ No				WORK ORDER NON-	100	NFORM	AANCE / UPDATE					
											QA Closed:	D:	ate:	
Work Orde	or.					DISPOSITION			AGAINS	T DE	PARTMENT	PROCESS		
Work Orac						Rework	1		Skid-tube Crosstub	e	1	Water Je	t	Engineering
Part I	No.					Scrap	1 1		Machining Small Fal	<u> </u>	Pro	d. Eng. Coor	-	Quality
	٠					Use-as-is	1 1		noforming Finishin	-	4	e/Packaging	-	Other
NCR I	Vo.					Work Order Update]		Large Fab Composite	e	1	Supplie	r	
Root			ļ .			ption of work order update		Initial	Action		Sign &	_		
Cause		Date	Step	Qty	•	or Non-conformance	Ch	ief Eng	Description		Date	Verification	<u>on</u>	QC Inspector
Doc/Data	Ш													
Equip/Tooling	Ш			[[1							
Operator	Ш													
Material	Ш]]							ļ			
Setup	\vdash													
Other	\vdash													
Process	\vdash													
Supplier	-						1							
Training														
Unapproved	<u>l</u>		<u> </u>	l			Διπ	LT CATE	GORY		<u> </u>			L
Landi	ing (Gear				General								
	Ť	Bending				Bend		Grain			Ovalized			Pressure/Forced
		Centre N	ot Conce	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct		Weld
	Г	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved			_
1		Heat Tre	at			Countersink		Mislabe	led		Positioned V	Vrong	_	_
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge		Other
		Ripples i	n Bend			Drill Holes		Offset						
		Torque V	Vaves in I	Extrusion	, [Drawing		Out of O	Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Work Order ID:

107248

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

NAS1149C0432R

WASHER

Purchased

No

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 1.00

Required Qty: 1.00

100 7,280.0000 2 2 Each DAS

Location		Loc Oty	Loc Code		28 9-89
ST292		2638			
11	19124	6			
12	21255	32			
12	21825	8			
12	22441	55			
m	125807	2545			
ST510a		4642			
m	126221	4642		$2\times$	

										DQA:	Date:	
NCR: Y	es /	No				WORK ORDER NON-C	ONFOR	MANCE / UPDATI		04614	D-4	
						• • •				QA Closed:	Date:	
Work Orde	ar.					DISPOSITION	1	A	GAINST DE	PARTMENT,	/PROCESS	
WOIR Olde						Rework		Skid-tube Cro	osstube		Water Jet	Engineering
Part N	lo					Scrap		Machining Sn	mall Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	Ther	moforming Fi	inishing	Rec/Stor	re/Packaging	Other
NCR N	۱o					Work Order Update		Large Fab Cor	mposite		Supplier	
Root						ption of work order update	Initial	Action		Sign &		
Cause	D	ate	Step	Qty		or Non-conformance	Chief Eng	Description	n	Date	Verification	QC Inspector
Doc/Data		}										
Equip/Tooling												
Operator							 		٠			
Material					·							
Setup					[
Other												
Process		1										
Supplier												
Training												
Unapproved							<u> </u>					
						F	AULT CAT	GORY				
Landi	ng Gear					General			_			7
	Ben	ding				Bend	Grain			Ovalized	L	Pressure/Forced
	Cen	tre Not	Concer	itric to	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
	Cra				ļ	Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
	Cru	shed/C	rimped			Burrs		tions Incomplete/Unclea	ar	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuff	s			<u>L</u>	Contamination	Maint	enance		Part Moved		
	Hea	t Treat				Countersink	Mislat	eled		Positioned V	Vrong	

Misread

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Cut Too Short

Drill Holes

Drawing

Finish Folio Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

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	ITEM	QTY -041	P/N	DESCRIPTION
		Х	D4030-041	LONG BASKET ASSY (350)
	1	1	D2530	HANDLE WELDMENT
	2	2	D2535	SPRING
	3	2	D2537	BUSHING
D	4	1	D3913-041	LONG BASKET BASE ASSY (350)
_	5	1	D3914-041	LONG BASKET LID ASSY (350)
	6	6	D3917-3	WASHER
	7	2	D3953-3	GAS SPRING STUD, LID
	8	2	D3953-7	GAS SPRING SPACER
	9	2	D3953-9	GAS SPRING WASHER
	10	2	D3953-17	GAS SPRING SPACER
_	11	1	D3953-19	GAS SPRING BRACKET
	12	1	D3953-21	GAS SPRING BRACKET
	13	1	D3969-3	SPRING
	14	4	AN3-14A	BOLT, MACHINE
	15	2	AN3-16A	BOLT, MACHINE
	16	3	AN4-12	BOLT, MACHINE
	17	4	AN5-17A	BOLT, MACHINE
С	18	2	AN310C4	NUT, PLAIN, CASTELLATED
	19	3	AN310-4	NUT, PLAIN, CASTELLATED
	20 .	6	MS21042L3	NUT, SELF-LOCKING
	21	4	MS21042L5	NUT, SELF-LOCKING
	22	2	MS24665-300	COTTER PIN
	23	3	MS24665-151	COTTER PIN
	24	2	NAS1149C0432R	WASHER
*	25	6	NAS1149F0432P	WASHER
	26	8	NAS1149F0332P	WASHER
	27	4	NAS1149F0563P	WASHER

107248 MLJ 13-09-23 D4030-041 LONG BASKET ASSY (350) (MESH SHOWN LOCALLY FOR CLARITY) DELEASED 2013 -08- 1 6

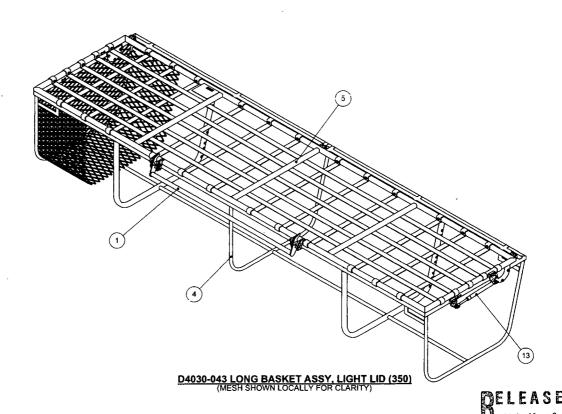
ם	REFORMAT FOR CLARITY. PICTORIAL UPDATÉ TO MULTIPLE VIEWS DUE TO CHANGES IN SUB ASSEMBLIES.	AJS	13.07.18
O	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM 3 WAS 4 (D8-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	мв	10.07.23
В	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
Α	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE

1			-,	
DESIGN	AJS	DART AERO	SPACE	LTD
DRAWN	AJS	HAWKESBURY, ON		
CHECKED	P	DRAWING NO.		REV. D
MFG. APPR.	120	D4030		SHEET 1 OF 4
APPROVED	rus	TITLE		SCALE
DE APPR.		☐ LONG BASKET AS	SSY (350	O) NTS
DATE 13.	07.18	COPYRIGHT © 2010 BY 1 THIS DOQUEST IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR C	SUPPLIED ON THE COPPE	ESS CONDITION THAT IT IS

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 72 lbs APPROX

С

ITEM	-043	P/N	DESCRIPTION	
	X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)	
1	1	D2530	HANDLE WELDMENT	
2	2	D2535	SPRING	
3	2	D2537	BUSHING	
4	1	D3913-041	LONG BASKET BASE ASSY (350)	
5	1	D3915-041	LIGHT LID ASSY, LONG BASKET	
6	6	D3917-3	WASHER	
7	2	D3953-3	GAS SPRING STUD, LID	
- 8	2	D3953-7	GAS SPRING SPACER	
: 9	2	D3953-9	GAS SPRING WASHER	
10	2	D3953-17	GAS SPRING SPACER	
- 11	1	D3953-19	GAS SPRING BRACKET	
12	1	D3953-21	GAS SPRING BRACKET	
13	1	D3969-3	SPRING	
. 14	4	AN3-14A	BOLT	
15	2	AN3-20A	BOLT	
1 16	3	AN4-12	BOLT	
1 17	2	AN5-17A	BOLT	
§ 18	2	AN5-21A	BOLT	
19	3	AN310-4	NUT, PLAIN, CASTELLATED	
20	2	AN310C4	NUT, PLAIN, CASTELLATED	
21	6	MS21042L3	NUT, SELF-LOCKING	
22	4	MS21042L5	NUT, SELF-LOCKING	
23	3	MS24665-151	COTTER PIN	
24	2	MS24665-300	COTTER PIN	
125	6	NAS1149F0432P	WASHER	
26	4	NAS1149F0563P	WASHER	
27	8	NAS1149F0332P	WASHER	
128	2	NAS1149C0432R	WASHER	



DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DESIGN DRAWN AJS DRAWING NO. CHECKED REV. D D4030 MFG. APPR. SHEET 2 OF 4 TITLE APPROVED SCALE LONG BASKET ASSY (350)

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THE PRINTED FOR THE PRINTED NTS DE APPR. DATE 13.07.18

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 57 lbs APPROX

8

